| Work Orde September-19-12 | er ID 90554 2 2:33:35 PM | | *90554* | | | | | | | | Page 1 |
|--------------------------------|---|---|---|------------------------|--------------|--------------|---------------|---------------|-------------|------------------|----------------|
| Revision ID: | D2013-2 Mirror Bracket RH, 205 | | Accept | *N900 | <u>)</u> 040 | 100 |)* | Setup St | art top | *N: | S1* S2* |
| 2. | 9/18/12 Start Qty: 4.00 10/12/12 Req'd Qty: 4.00 | *4* *4* | | Cust Item Customers | | | | | | | |
| Approvals: | Process Plan: ML5 QC: | Date: 12 - 09 - Zo Tooling: Date: SPC (Y/N): | | Date: | | | | | tart top | | R1* R2* |
| Sequence ID/ Work Center II | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | | Reject Number | Insp. Stamp |
| Draw Nbr | Revision Nbr | | | | | | | | | | |
| D2013 | Rev C | | | | | | | | | | |
| 100 *100* Brake NC Brake NC | 2-Flatten e | | 0.00 0.00 Dwg D2013 Dwg D2013 using DT8545 ng Jig DT82011dentify as D | 2013-2. | | | -4 | 4 | | | -01-02 |
| *110 *110* QC Quality Control | | pleteness to step on W/O | 0.00 15 15 8-89 0.00 13.01-03 | , | | | <u>'</u> | | | | |
| 115 *115* Packaging Packaging | Identify as per dwg & S Memo | Stock Location: WA (10 | 0.00 | | | | 9 | | 2. | /3-/ <i>-</i> | -3 |

| NCR: Y | es , | / No | | | | WORK ORDER NON-O | O | NFORM | ANCE / UP | DATE | | | | | | | |
|--|-----------------------|------------|------------|------------------|----------|----------------------------|----------|----------------------------|------------------|-----------|--------------|---------------|--------------------|--|--|--|--|
| | | _ | | | | | | | | | QA Closed: | Date | | | | | |
| Work Orde | ar: | | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | | | | |
| WOIK Olde | - | | | | | Rework | 1 | | Skid-tube | Crosstube |] | Water Jet | Engineering | | | | |
| Part N | No. | | | | | Scrap | 1 | | Machining | Small Fab | Prod | d. Eng. Coor. | Quality | | | | |
| , 4 | - | | | | | Use-as-is | 1 | l . | noforming | Finishing | | e/Packaging | Other | | | | |
| NCR N | No. | | | | | Work Order Update | | | Large Fab | Composite |] | Supplier | | | | | |
| ······································ | | | | | | | | | | · | C: 0 | | | | | | |
| Root | | _ | | | | ption of work order update | ł | nitial | | tion | Sign & | Varifiantian | OCInchester | | | | |
| Cause | | Date | Step | Qty | • | or Non-conformance | Ch | ief Eng | Descr | ription | Date | Verification | QC Inspector | | | | |
| Doc/Data | Н | | | | | | | | | | | | | | | | |
| Equip/Tooling | \blacksquare | | | | | | | | | | | 2 | | | | | |
| Operator | \vdash | | | | | | | | | | | | | | | | |
| Material | \vdash | | | | | | | | | | | | | | | | |
| Setup | Н | | İ | | | | | | | | | | | | | | |
| Other | \vdash | | | | | | | | | | | | | | | | |
| Process | H | | | | | | | | | | | | | | | | |
| Supplier | Н | | | | | | | | | | | | | | | | |
| Training | H | |] | | | | | | | | | | | | | | |
| Unapproved | <u> </u> | | l | J | <u> </u> | | L AUI | T CATE | I GORY | | | <u> </u> | <u></u> | | | | |
| Landi | ng Ge | ear | | | | General | | | | | | | | | | | |
| | | Bending | | | Γ | Bend | | Grain | | | Ovalized | | Pressure/Forced | | | | |
| | П | Centre No | ot Conce | ntric to | o/s | BOM/Route | | Hardwa | ire | | Over/Under | tolerance | Temperature/Cure | | | | |
| | | Cracks | | | | Broken/Damaged | | Inspect | ion Incomplete | <u> </u> | Part Incorre | ct | Weld | | | | |
| | \Box | rushed/ | Crimped | , | - | Burrs | | Instruct | ions Incomplete/ | Unclear | Part Lost/M | issing | Wrong Stock Pulled | | | | |
| | $\boldsymbol{\vdash}$ | Cuffs | • | | | Contamination | | Mainte | enance | | Part Moved | _ | - | | | | |
| | H, | leat Trea | it | | | Countersink | | Mislabe | eled | | Positioned V | V rong | _ | | | | |
| | $\sqcap_{}$ | nspectio | n Strip in | Tube | | Cut Too Short | | Misrea | d | Γ | Power Loss/ | 'Surge | Other | | | | |
| | ∏F | Ripples in | Bend | | | Drill Holes | | Offset | | _ | | | | | | | |
| | Пı | orque W | aves in l | Extrusi o | n 🗀 | Drawing | | Out of | Calibration | | | | | | | | |

Out of Sequence

Outside Dimensions

DQA:

Date:

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Turning Sequence

Wave/Twist in Tube

Finish

Folio

| Work Order ID 90554 September-19-12 2:33:35 PM | | | *90554* | | | | | | | | | Page 2 |
|---|-------------------------|---|----------------------|------------------------------|--------------------------|-------------|--------------|---------------|------------|---------------|------------------|----------------|
| Item ID: Revision ID: Item Name: | D2013-2 Mirror Brack | ket RH, 205 | | Accept | *N900 | 04 0 | 100 |)* | Setup | Start Stop | | S1* S2* |
| Start Date: Required Date: Reference: | 9/18/12 10/12/12 | Start Qty: 4.00 Req'd Qty: 4.00 | *4* *4* | | Cust Item I Customer: | D: | | | | | | |
| Approvals: | Process P | lan: | Date: | Tooling: SPC (Y/N): | | nte: | | | Run | Start Stop | *N *N | R1* R2* |
| Sequence ID/ Work Center II 120 *120* QC Quality Control | D | Operation Description QC21- Final Inspection Memo | - Work Order Release | Set Up/ Run Hours 0.00 | Tool ID | Tool # | Plan Code | Accept Qty | t Re Qt | | Reject Number | Insp. Stamp |

U 13-01-03

| | | | | | | | | | | | DQA: | Date | <u>:</u> |
|---|--|-------------------------|----------|------|--------|--|-----|---|---------------|---------------------|--|--|--|
| NCR: Y | ⁄es | / No | | | | WORK ORDER NON-C | O | NFORM | /ANCE / UPDAT | | - QA Closed: | Date | 2: |
| Work Orde | or. | | | | | DISPOSITION | | : | , | AGAINST DEF | PARTMENT | PROCESS | |
| Part N | - - ۱٥٠ | | | | | Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite | | | | Small Fab Finishing | | Water Jet d. Eng. Coor. e/Packaging Supplier | Engineering Quality Other |
| Root | | | | | Descri | ption of work order update | | Initial | Action | | Sign & | | |
| Cause | | Date | Step | Qty | (| or Non-conformance | Ch | ief Eng | Description | on | Date | Verification | QC Inspector |
| Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved | | | | | | | | | | | | | |
| | LL. | | <u> </u> | 1 | L | F | AUL | T CATE | GORY | | | | |
| Landii | Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat | | | | | General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short | | Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled | | | Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong | | Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other |
| | - | nspection Ripples in | • | rube | | Drill Holes | - | Misrea Offset | 1 | <u> </u> | Power Loss/ | Juige [| Jouren |

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

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Page 1

Work Order ID:

90554

Parent Item:

D2013-2

Parent Item Name:

Mirror Bracket RH, 205

Start Date: 9/18/12

Required Date: 10/12/12

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A

New Issue 05-11-01 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|----------------|---------------|----------------|--------|
| M304TR0.750W.049 304 RD Tube .750 x .049 | W | Purchased | No | | | 100 | f | 639.1204 | 1.9473 | 8.199158 AD | 12-1 | \$-0 | 7 |
| | | , | | Location | | Loc Oty | Los | c Code | _ | - | | | |
| | | | | MAT017 | | 639.120417 | | | | | | | |
| | | | | 109 | 314 | 9.333 | | | | | | | , |
| | | | | 111 | 619 | 3 | | | | | | | |
| | | | | 112 | 187 | 4 | | | | | | | |
| • | | | | 112 | 800 | 11 | | | | | | | |
| | | | | 114 | 852 | 2.75 | | | | | | | |
| <u>}</u> | | | | 116 | 108 | 3 | | | | | | | |
| T. | | | | 117 | 797 | 0.75 | | | <u></u> | | | | • |
| | | | | 120 | 441 | 0.000794 | | | | | | | |
| | | | | 121 | 170 | 234.89 | | | | | | | |
| | | | | 121 | 666 | 10.232 | | | | | | | |
| | | | | 122 | 312 | 87.19 | | | | | | | |
| | | | | 122 | 468 | 272.974623 | | | -3_ | 1992 | | | |

| | | | | DQA: | Date: | | |
|---------------|--------------------|-----------------|-------------|-------------|-----------|-------------|---|
| NCR: Yes / No | WORK ORDER NON-CON | IFORMANCE / UPE | | QA Closed: | Date: | <i>:</i> | |
| Work Order: | DISPOSITION | | AGAINST DEP | ARTMENT/PR | OCESS | | |
| work Order. | Rework | Skid-tube | Crosstube | \ | Water Jet | Engineering | |
| Part No. | Scrap | Machining | Small Fab | Prod. E | ng. Coor. | Quality | |
| | | Thormoforming | Einiching | Rac/Stora/D | ackaging | Other | İ |

| NCR No | D | | | | Use-as-is Work Order Update | The | rmoforming Large Fab | Finishing Composite | _ | re/Packaging Supplier | Other | |
|--|-------------------------------------|----------|------------|----|--|---------------------|--|------------------------|-------------------------------------|---------------------------------------|----------------------------------|--|
| Root Cause | Date | Step | Qty | | ption of work order update or Non-conformance | Initial Chief En | 1 | ction scription | Sign & Date | Verification | QC Inspector | |
| Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved | | | | | | | | | | | | |
| | ······· | | | | F | AULT CAT | EGORY | | | | | |
| Landing | g Gear | | | | General | | | | | _ | | |
| | ; | ot Conce | ntric to O | /s | Bend BOM/Route | Grain | ware | | Ovalized Over/Under | ⊢ | Pressure/Forced Temperature/Cure | |
| - | Cracks Crushed/Crimped Cuffs | | | | Broken/Damaged Burrs Contamination | Instru | ction Incomplete actions Incomplete atenance | e/Unclear | Part Incorre Part Lost/M Part Moved | Weld Wrong Stock Pulled | | |
| F | Heat Treat Inspection Strip in Tube | | | | Countersink Cut Too Short | Misla | Mislabeled Misread | | | Positioned Wrong Power Loss/Surge Oth | | |
| F | Ripples in | | Extrusion | | Drill Holes Drawing | Offse Out o | t of Calibration | | | | | |
| | | Sequence | | | Finish | Out | of Sequence | • • • | | | | |

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio